

Date: Wednesday, 06/09/2006 11:05:17 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GPS BOTTOM MOUNTING
Job Number	: 28422	Part Number	: D35301
Estimate Number	: 12518	Drawing Number	: UNDER REVIEW <i>EC 06-09-05</i>
P.O. Number	:	Project Number	: N/A
This Issue	: 06/09/2006	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 13/09/2006
Previous Run	:	Qty:	2
Written By	: <i>RL</i>	Um:	Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-08.30 EC		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S040	6061-T6 .040 Sheet	
		Comment: Qty.: 0.4812 sf(s)/Unit Total : 0.9624 sf(s) <i>6061-T6 .040 Sheet</i> <i>(M6061T6S040)</i> Batch: <i>M19380</i>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg P3530 Dwg Rev: <i>Pre</i> Prog Rev: <i>Pre</i>	 <i>M 06 09 06</i> (1)
		2-Deburr if necessary	 <i>M 06 09 06</i> (2)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <i>M 06 09 06</i> (2)
4.0	QC8	SECOND CHECK	 <i>EC 06-09-06</i> (2)
		Comment: SECOND CHECK	<i>EC 06-09-06</i> (2)
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	 <i>EC 06-09-06</i> (2)
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<i>A.M 06-09-07</i> (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING	POWDER COATING
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
8.0	PACKAGING 1	PACKAGING RESOURCE #1
9.0	QC21	FINAL INSPECTION/W/O RELEASE

Job Completion



W 07.03.09

Eng Approval

CB 07.03.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

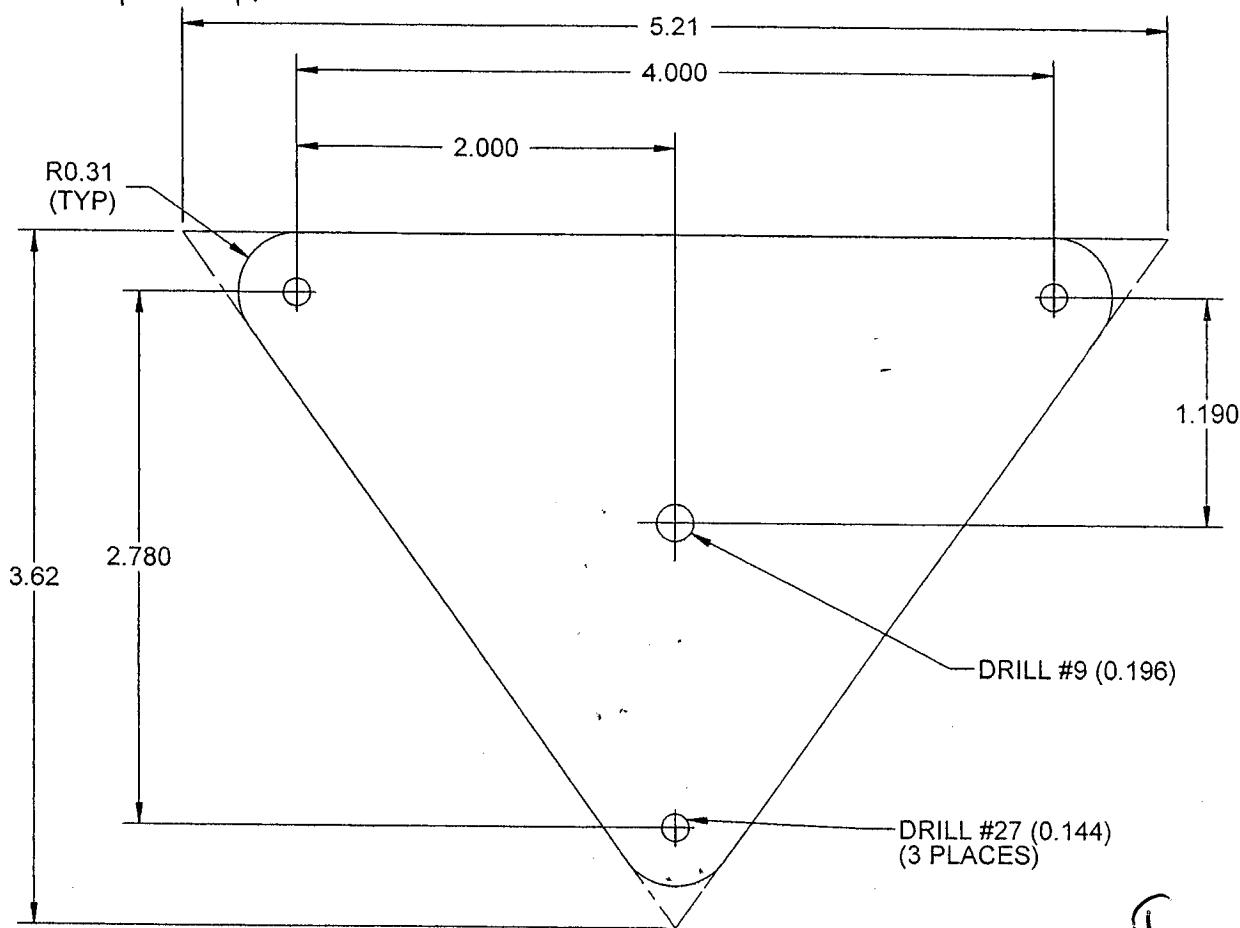
PRELIMINARY ISSUE

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3530	
DATE	06.06.21	TITLE	REV. A SHEET 1 OF 2
		GPS BOTTOM MOUNTING	SCALE 1:1
A	06.06.21	NEW ISSUE	

UNDER REVIEW

06.08.22 CB

prototype



D3530-1F FLAT PATTERN

EST done

Prog

D3530-1 BASE PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD	Work Order:	28422
Description: GPS Bottom Mounting	Part Number:	3530-1
Inspection Dwg: \ Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article **x** Prototype

Measured by:	M. MM	Audited by:	R	Prototype Approval:	CB
Date:	06.09.06	Date:	06.09.06	Date:	07.03.08

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DOC : V/0080151422

DATUM : 2005-04-18

PROD. REF. : 0000175932/001

NRBST : 58848/01

PAGINA : 1/ 1

KEURINGSRAPPORT



Corus Aluminium N.V.
A. Slobstraat 87, 2570 Duffel - Belgium
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

KLANT : COPPER AND BRASS SALES
CORPORATE SERVICES DIVISION
SOUTHFIELD, MI USA

UW ORDERNUMMER : PO3944 (COPPER'S PO#CC1837)
ONS ORDERNUMMER : 58848/01
DOCUMENT NUMMER : V/0080151422

SPECIFICATIES: ALU SHEETS(STENCI) AA6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04
AFMETINGEN : 144" X 48" X 0,04"
ARTIKEL NR.: 6061-T6

ROL-
NUMMER GEUT-
NUMMER

CHEMISCHE ANALYSE (%)

		SI MIN	FE MAX	CU 0,15	MN 0,15	MG 0,8	CR 0,04	TI 1,2	ZN 0,35
001	7124901	0,40	0,7	0,40	0,15	0,8	0,04	0,15	0,25
002	7124901	0,67	0,4	0,22	0,09	1,1	0,16	0,02	0,01

ANDERE : ELK
TOTAAL : MIN
MIN 0,05 MAX
0,15 MAX

TEST-
NUMMER

MECHANISCHE EIGENSCHAPPEN
1 N/MM² = 1 MPA = 0,1 HBAR = 0,102 KG/MM² = 0,145 KSI
/A = ACHTER /M = MIDDEN /V = VOOR /O = RANDOM

		RM MIN	RP02 KSI 42	A % 35	10
001	/A		47	39	16
001	/M		47	39	15
001	/V		47	39	16
002	/A		47	39	16
002	/M		48	40	16
002	/V		48	39	16

COPPER AND BRASS SALES

SOLD TO: 198

DATE: 10/16 QTY. 20

CUSTOMER PO: 00000000

SHIPPER NO: 4V3428

BY: _____

Corus Aluminium Rolled Products - Corus Aluminium Extrusions